

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D212-601 REV. B

REF TCCA STC SH93-96

## PURPOSE

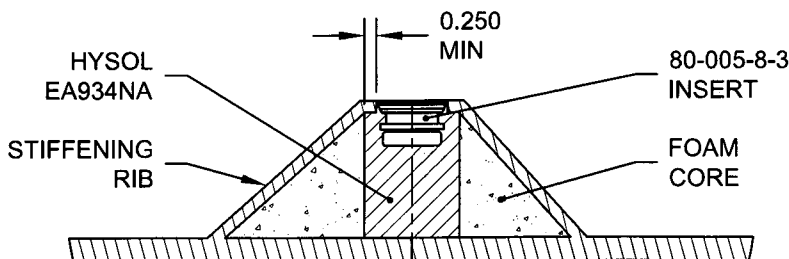
TO ALLOW INSTALLATION OF POTTED INSERTS AND PERFORM CUTOUTS REQUIRED FOR THE INSTALLATION OF EQUIPMENT INSIDE THE D212-601-041/-042 HELI-UTILITY-POD.

## CHANGE

IT IS ACCEPTABLE TO INSTALL UP TO 3 X 80-005-3-8 INSERTS, MINIMUM 4" APART, IN EACH STIFFENING RIB OF THE POD BASE FOR THE INSTALLATION OF EQUIPMENT USING THE FOLLOWING PROCEDURE:

1. LOCATE AND MARK THE CENTER(S) OF THE INSERT(S) ACCORDING TO THE COMPONENT LOCATION DRAWING (LOCATION AND INSTALLATION OR ASSEMBLY).
2. MAKE A HOLE THE SAME SIZE DIAMETER AS THE INSERT SHAFT DIAMETER. DRILL INTO THE MATERIAL WITHOUT SCORING THE FAR SIDE OF THE SANDWICH MATERIAL. ROUTE THE MATERIAL UNDER THE HOLE AND CLEAN OUT FOAM CORE BETWEEN THE TOP AND BOTTOM LAYERS OF THE SANDWICH MATERIAL. ENLARGE DIAMETER OF FOAM CORE TO AT LEAST 0.250" ALL AROUND HOLE AS SHOWN IN FIGURE 1 BELOW (SUGGESTION: A HEX-HEAD WRENCH CHUCKED INTO A SLOW SPEED DRILL MAKES THIS STEP EASY, QUICK AND UNIFORM).
3. PLACE THE INSERT ASSEMBLY INTO THE HOLE AND FLUSH TO THE TOP SURFACE. FILL HOLE 2/3 WITH HYSOL EA934NA PRIOR TO INSTALLATION OF THE INSERT.
4. TO INSTALL EACH INSERT, USE HYSOL EA934NA IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS. HYSOL EA934NA MAY BE INJECTED WITH A SEALANT GUN OR SYRINGE THROUGH THE INSERT'S POTTING HOLE. THE CAVITY IS FILLED WHEN HYSOL APPEARS IN THE VENT HOLE. ALLOW A MINIMUM CURE TIME OF 24 HOURS AT ROOM TEMPERATURE.
5. AFTER THE CURING TIME, REMOVE EXCESS HYSOL BY SANDING FLUSH TO THE TOP SURFACE OF THE INSERT.
6. TOUCH UP FINISH USING DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S.

IT IS ACCEPTABLE TO CUT HOLES IN THE BASE OF THE POD (UP TO 25in<sup>2</sup> IN AREA), SIDES AND LID OF THE POD (UP TO 10in<sup>2</sup> IN AREA) AS LONG AS THE HOLES DO NOT COMPROMISE THE LARGE TRANSVERSE STIFFENING RIBS IN THE POD. EACH HOLE MUST BE A MINIMUM OF 12" AWAY FROM THE NEXT HOLE. SEAL THE EDGES OF THE HOLES WITH CYANOACRYLATE GLUE (CRAZY GLUE).



**FIGURE 1**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)

DATE: 13.03.25  
CERT. NO.: SH93-96  
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A	NEW ISSUE	MB	10.09.24
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DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9533	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		HELI-UTILITY-POD MODIFICATIONS	NTS
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